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RBW6705G02331-3G**Job Sheet 200657****Part No:** RBW6705G02331-3G**Job Qty:** 4 pcs**Part Name:** Rigging Pin Assembly N4**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 9/13/19**Job Tracking No:****Due Date:** 10/7/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:** SIOP

Note: RBW6705G02331-3G REV.3 IPP Rev.A New issue 17/11/07 JFS Verified by:DP IPP REV:B 17.12.12 ADDED
MILL CONV AND QC5 DD VERF:JFS

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	4 pcs	10/7/19		0.00	1.33	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
110	QC 5	4 pcs	10/7/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
115	Conventional Mill - 1 - B4B	4 pcs	10/7/19		0.00	0.67	Conventional Mill - 1 - B4B		
							Conventional Mill - 2 - B4B		

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117	QC 5	4 pcs	10/7/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
120	Outsource - 1 - Heat Treat	4 pcs	10/7/19		MEI001-VC	10
122	Packaging 2-1 - Receive - B4B	4 pcs	10/7/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
124	QC 6	4 pcs	10/7/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	

				QC 6 - 61	
				QC 6 - 40	
				QC 6 - 81	
130	Outsource - 13 - Zinc Plating	4 pcs	10/7/19	GRO002-VC	10
140	Packaging 2-2 - Receive - B4B	4 pcs	10/7/19	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B
					Packaging 2 - 24 - B4B
					Packaging 2 - 25 - B4B
					Packaging 2 - 26 - B4B
					Packaging 2 - 27 - B4B
					Packaging 2 - 28 - B4B
					Packaging 2 - 29 - B4B
					Packaging 2 - 30 - B4B
					Packaging 2 - 31 - B4B
					Packaging 2 - 32 - B4B
					Packaging 2 - 33 - B4B
					Packaging 2 - 34 - B4B
					Packaging 2 - 35 - B4B
					Packaging 2 - 36 - B4B
150	QC 6	4 pcs	10/7/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
					QC 6 - 81
160	Small Fab - 2 - B4B	4 pcs	10/7/19	0.00 0.67	Small Fab - 1 - B4B
					Small Fab - 2 - B4B
					Small Fab - 3 - B4B
					Small Fab - 4 - B4B
					Small Fab - 5 - B4B
					Small Fab - 6 - B4B
					Small Fab - 7 - B4B
					Small Fab - 8 - B4B
170	QC 5	4 pcs	10/7/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19

				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
190	Packaging 3-1 - Stock - B4B	4 pcs	10/7/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
200	QC 21 - SA	4 pcs	10/7/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
Part Op 100 - (Small Fab) 1- Bend as per dwg. 2- Cut to Finished length. 3- Grind chamfer. Descriptions: 110 - (QC5- Inspect part completeness to step on W/O) 115 - (Manufacture as per dwg) DRILL HOLE AS PER DWG 117 - (QC5- Inspect part completeness to step on W/O) 120 - (Outsource process - Heat Treat) 1--Issue P/O to Metcore ; P/O _____ RC: 26-30 2-Bead blast 3- Certificate of Conformity is required 122 - (Receive & Inspect for Damage & Mat'l Certs)					

- 124 - (QC6- All purchased or subcontracted products)
 130 - (Outside Processing - Zinc Plating) -Issue P/O to Groupe Altech: P/O _____ -Zinc plate, ASTM B633 TYPE
 1 SC2 - Certificate of Conformity is required
 140 - (Receive & Inspect for Damage & Mat'l Certs)
 150 - (QC6- All purchased or subcontracted products)
 160 - (Small Fab) - Install lanyard as per dwg.
 170 - QC5- Inspect part completeness to step on W/O
 190 - (Identify as per dwg & Stock Location: _____)
 200 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
8893K204	Ø1/4 O1 Tool Steel Rod MT-O1-R0.250	2.235	100-Small Fab - 1	S216739
3896T31	Ferule 1/16 X 3/8" - Aluminum	8 Ea (2 ea)	160-Small Fab - 2 - B4B	S215202
CL-2-C	Lanyard Wire	4 ft (1 ea)	160-Small Fab - 2 - B4B	S192012
NAS1756-12	Remove Before Flight	4 Ea (1 ea)	160-Small Fab - 2 - B4B	S200859
MT-O1-R0.250		.745		

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	8893K204	3	0	0
160-Small Fab - 2 - B4B	3896T31	8	670	0
	CL-2-C	4	1,129	0
	NAS1756-12	4	333	0

Part Specifications

Specifications could not be found.

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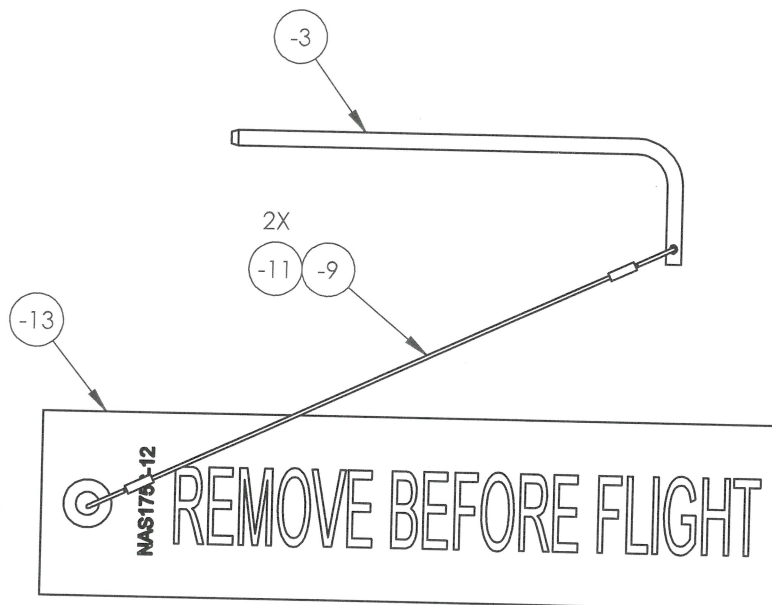
2.235 - S216739

.745 - S026994

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		CORRECTED BOM -3 FROM Ø3/16, CH'D BEND RADIUS FROM .563.	4/25/2011	RJC	RW
1		DELETED -1 WELDMENT, -5 AND -7. -3 EXTENDED PIN SHORT END FROM 1.62 TO 2.04, ADDED Ø.094 HOLE FOR LANYARD.	8/29/2012	RJC	SE
2		-3 CH'D BEND RADIUS WAS R.56 IS R.50.	2/12/2013	BIM	GE
3	15-0097	-3 CORRECTED VIEW NO CHAMFER ON SHORT END OF PIN. -9 CH'D B/O INFO WAS REID #CL2C, IS CARR-LANE #CL-2-C.	4/22/2015	RJC	JAG

TEO ATTACHED



200657 MLW
19-09-13

NOTES:

- PART OF KIT RBW6705G00132-3G.
- QUANTITY 1 PER KIT.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-3	1	PIN N°4	O-1		2
		B/O	-9	1	LANYARD CABLE	COATED STEEL	Ø1/16 X 10 (CARR LANE #CL-2-C)	1
		B/O	-11	2	FERRULE	ALUMINUM	Ø1/16 X 3/8 (MCMASTER-CARR #3896T31)	1
		B/O	-13	1	REMOVE BEFORE FLIGHT FLAG	NYLON	NAS 1756-12 (AIRCRAFT HARDWARE)	1

DART AEROSPACE	
TITLE RIGGING PIN ASSY. N° 4	
DWG NO. RBW6705G02331-3G	
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/8 ANGLES ± 5° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	DRAWN BY: PERRITT APPROVED <i>D Weil</i> HEAT TREAT FINISH SPEC USED ON MODEL AGUSTA
SCALE 1:3	DATE 1/28/2010
SHEET 1 OF 2	

Entered: JR Date: Oct 22/19



NCR No. 19-7483

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only



Job: <u>RBW6705G02331-36</u> Part No. <u>200657</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☒ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐							
Date: <u>19-10-21</u>		Sequence #: <u>105</u>		QTY Affected: <u>4</u>		MRB (QSI042)					
Description Work Order Deviation				Disposition							
Design change. Job was started under Rev 3 but got revise to Rev E				ECN 19-216 Part must comply.							
								Completed By			
								Lead hand / Supervisor			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☒ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY Pressure/Forced ☐ Contamination ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Misaligned/off center ☐ Folio/Program ☐ Outside Tolerance ☐ Crushing ☐ BOM/Route ☐ Grain Direction ☐ Drawing ☒ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Finish ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Incomplete/Unclear Instructions ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Marks/Chatter ☐ Drill Holes ☐ Out of Sequence ☐ Misread ☐ Mislabeled ☐ Fit/Function ☐ Off-set/Set-up ☐							
Other/Details:											